In the Claims:

Amend the claims as follows.

1.(original) An electric discharge machine for machining a workpiece in a desirable manner by applying electric discharge machining voltage between an electrode and said workpiece while feeding said electrode and said workpiece relative to each other to control a machining gap, said. electric discharge machine comprising:

a spindle provided with attachment means for detachably attaching an electrode holder to said spindle;

said electrode holder having an engagement portion for engaging with said attachment means of said spindle and provided with electrode holding means for holding said electrode in said electrode holder;

an electrode guide holder including an engagement portion for engaging with said electrode holder and having attached thereto an electrode guide for supporting and guiding said electrode; and

electrode guide holder supporting means for supporting said electrode guide holder so that said electrode guide supports a distal end of said electrode, said electrode guide holder supporting means having gripping means for gripping said electrode guide holder and provided with moving means for moving said electrode guide holder in parallel to an axis of said spindle.

2.(currently amended) An electric discharge machine for machining a workpiece in a desirable manner by applying electric discharge machining voltage between an electrode and said workpiece while feeding said 1.ectrode and said workpiece relative to each other to control a machining gap, said electric discharge machine comprising:

a spindle provided with attachment means for detachably attaching said electrode or an electrode holder to said spindle;

said electrode holder having an engagement portion for engaging with said attachment means of said spindle and provided with electrode holding means for holding said electrode in said electrode holder;

an electrode guide for supporting and guiding said electrode held in said electrode holder;

an electrode guide holder adapted to be detachably attached to said electrode holder and having said electrode guide attached thereto; and

electrode guide supporting means for supporting said electrode guide, said electrode guide supporting means having gripping means for gripping said electrode guide or said electrode guide holder and provided with moving means for moving said electrode guide or said electrode guide holder in parallel to an axis of said spindle.

3.(original) The electric discharge machine according to claim 1 or 2, wherein said spindle is attached to a spindle head, so that said spindle can be moved in a direction along the axis of said spindle and rotated about the axis of said spindle as well as be positioned at a desired position.

4.(original) The electric discharge machine according to claim 1 or 2, wherein said electrode holder has a flow path formed therein for introducing working fluid into a pipe electrode when said pipe electrode is held therein.

5.(original) The electric discharge machine according to claim 1, wherein said electrode guide holder supporting means is attached to a suitable position on said spindle head or a machine body and has gripping means for gripping said electrode guide holder, so that the

electrode guide holder can be gripped by said gripping means to move parallel to the axis of said spindle and positioned at a desired position.

6.(original) The electric discharge machine according to claim 1 or 2, further comprising electrode holder replacement means for transferring said electrode holder between said spindle and an electrode magazine for storing one or more electrode holders.

7.(original) The electric discharge machine according to claim 1 or 2, wherein said electrode guide holder has a tapered—shaped distal end opposed to said workpiece, on which said electrode guide is detachably mounted.

8.(original) The electric discharge machine according to claim 1 or 2, further comprising an anti-vibration guide movable toward and away from a lengthwise middle portion of said electrode mounted on said spindle and capable of holding and guiding said electrode when moving toward said middle portion.

9.(currently amended) A method for machining a workpiece in a desirable manner in an electric discharge machine by applying electric discharge machining voltage between an electrode and said workpiece while feeding said electrode and said workpiece relative to each other to control a machining gap, said electric discharge machine comprising a spindle provided with attachment means for detachably attaching an electrode holder to said spindle, said electrode holder having an engagement portion for engaging with said attachment means of said spindle and provided with electrode holding means for holding said electrode in said electrode holder, an electrode guide holder including an engagement portion for engaging with said electrode holder and having attached thereto an electrode guide for supporting and guiding

said electrode, and electrode guide holder supporting means for supporting said electrode guide holder so that said electrode guide supports a distal end of said electrode, said electrode guide holder supporting means having gripping means for gripping said electrode guide holder and provided with moving means for moving said electrode guide holder in parallel to an axis of said spindle,

said method comprising the steps of:

(a) mounting ~~an electrode guide~~ said ~~or an~~ electrode guide holder on said ~~an~~ electrode holder having an electrode held therein in advance;

(b) mounting said electrode holder on said ~~a~~ spindle manually or by electrode holder replacement means;

(c) gripping said electrode guide holder by said electrode guide holder suporting means and moving said electrode guide to said ~~a~~ distal end of said electrode to support said electrode; and

(d) moving said electrode and said workpiece relative to each other to position said electrode at a position on said workpiece to be machined and start the electric discharge machining.

10.(currently amended) A method for machining a workpiece in a desirable manner in an electric discharge machine by applying electric discharge machining voltage between an electrode and said workpiece while feeding said electrode and said workpiece relative to each other to control a machining gap, said electric discharge machine comprising a spindle provided with attachment means for detachably attaching an electrode holder to said spindle, said electrode holder having an engagement portion for engaging with said attachment means of said spindle and provided with electrode holding means for holding said electrode in said electrode holder, an electrode guide holder including an engagement portion for engaging with

said electrode holder and having attached thereto an electrode guide for supporting and guiding said electrode, and electrode guide holder supporting means for supporting said electrode guide holder so that said electrode guide supports a distal end of said electrode, said electrode guide holder supporting means having gripping means for gripping said electrode guide holder and provided with moving means for moving said electrode guide holder in parallel to an axis of said spindle,

said method comprising the steps of:

mounting on said ~~a~~ spindle of said ~~an~~ electric discharge machine said electrode or said ~~an~~ electrode holder having said electrode held therein;

inserting said electrode into said ~~an~~ electrode guide or said ~~an~~ electrode guide holder gripped by said electrode guide supporting means ~~for supporting said electrode guide movable parallel to an axis of said spindle~~ so that a distal end of said electrode is supported by said electrode guide;

moving said electrode and said workpiece relative to each other to position said electrode at a position on said workpiece to be machined; and

applying electric discharge machining voltage between said electrode and said workpiece while feeding said electrode and said workpiece relative to each other to carry out the electric discharge machining on said workpiece.

11.(currently amended) A method for machining a workpiece in a desirable manner in an electric discharge machine by applying electric discharge machining voltage between an electrode and said workpiece while feeding said electrode and said workpiece relative to each other to control a machining gap, said electric discharge machine comprising:

a spindle provided with attachment means for detachably attaching an electrode holder to said spindle,

said electrode holder having an engagement portion for engaging with said attachment means of said spindle and provided with electrode holding means for holding said electrode in said electrode holder,

an electrode guide holder including an engagement portion for engaging with said electrode holder and having attached thereto an electrode guide for supporting and guiding said electrode,

electrode guide holder supporting means for supporting said electrode guide holder so that said electrode guide supports a distal end of said electrode, said electrode guide holder supporting means having gripping means for gripping said electrode guide holder and provided with moving means for moving said electrode guide holder in parallel to an axis of said spindle, and

electrode holder replacement means for transferring said electrode holder between said spindle and an electrode magazine for storing one or more electrode holders,

said method comprising the steps of:

holding said electrode in said ~~an~~ electrode holder;

mounting said ~~an~~ electrode guide holder on said electrode holder so that said electrode is inserted into said ~~a~~ electrode guide of said electrode guide holder;

accommodating said electrode holder in said ~~an~~ electrode magazine of said ~~an~~ electric discharge machine;

taking out said electrode holder from said electrode magazine by said electrode holder replacement means and mounting said electrode holder on said ~~a~~ spindle of said electric discharge machine;

releasing the mounting of said electrode guide holder on said electrode holder and moving said electrode guide holder parallel to an axis of said spindle by said electrode guide

holder supporting means so that said ~~a~~ distal end of said electrode is supported by said electrode guide;

moving said electrode and said workpiece relative to each other to position said electrode at a position on said wotkpiece to be machined; and

applying electric discharge machining voltage between said electrode and said workpiece while feeding said electrode and said workpiece relative to each other to carry out the electric discharge machining on said workpiece.